

Work Order ID 61948

Friday, September 10, 2010 9:21:58 AM

ASAP



Page 1

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 9/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: UMF Date: 10-9-10 Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3512	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3512 ☒ Dwg Rev: C ☐ Prog Rev: C 12-
Deburr if necessary

B10-9-20

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-9-20

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Solori/zi

(412)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr if necessary ☐ Form as per dwg D3512 using DT8179

8/10/09/22

(12)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

8/10/09/22

(42)

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004 ☐ Qty
Description Batch ☐ A/R 2059b Hardcoat Rod m115553

EZ 10-9-30 (X12)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

12

100830

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

12

100830

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:05

OVEN TEMPERATURE:

320

FINISH TIME:

11:35

12

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

27 25

10/10/05

12

0



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 500

0.00



Packaging

Memo

0.00

Packaging

10/10/05 12

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05
CMF
10-10-05

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, September 10, 2010 9:21:57 AM

Page 1

Work Order ID: 61948



Parent Item: D3512-1



Parent Item Name: Wearplate

Start Date: 9/10/2010

Required Date: 9/14/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

26.2000

0.261

1.648421

3.2



1B10-9-20

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT20

26.2

115440

26.2

115668

115668

12

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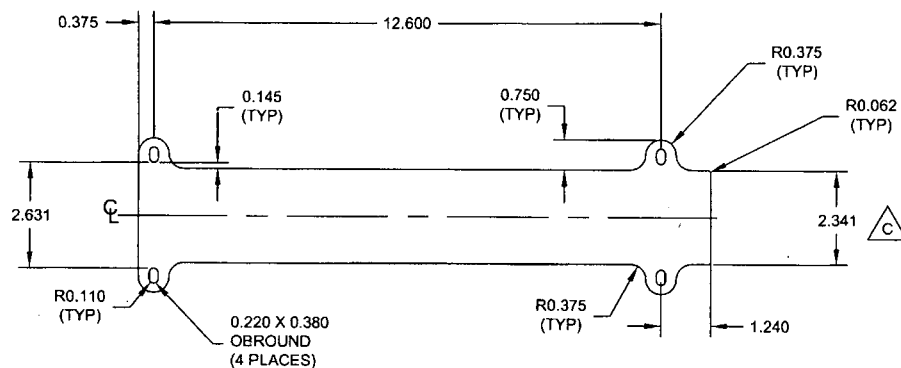
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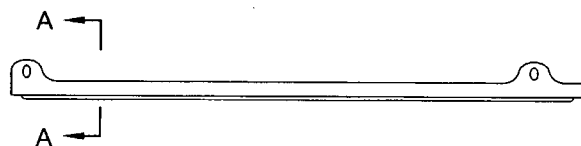
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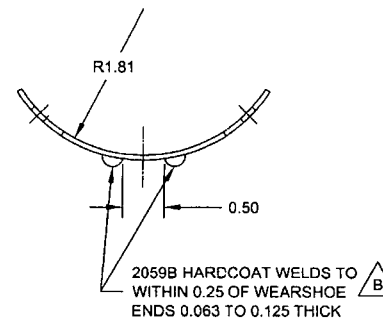
NOTE: Date & initial all entries



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3

#61948

RELEASED
67-11-16



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

C	ENLARGE OBROUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3512
TITLE WEARPLATE
SCALE 1:3

REV. C
SHEET 1 OF 1

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